

June 25

Work Order ID 83772

83772

April-25-12 10:12:27 AM

Item ID: D350-591-311

Accept

N900040100

Setup Start *NS1*

Revision ID:

Stop *NS2*

Item Name: Heli-Access-Step, Long LH

Start Date: 25/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals: Process Plan: MLJ

Date: 12/04/26 Tooling:

Date:

Run Start *NR1*

QC:

Date: SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr	Revision Nbr
----------	--------------

D3272	Rev B
-------	-------

100

0.00

100

DOCUMENT CONTROL

DC

Memo

0.00

Document Control

Photocopy bluefile and type labels as per PPP D350-591-311 CHG001

Handwritten: 8/10/03 JB

Handwritten: 10 for MLJ 12-6-6 (10)

110

0.00

110

Large Fab

Large Fab

Memo

0.00

Large Fab

1-Bevel end for welding FWD ONLY

2-Weld Support using Jig DT8719, weld Fwd End Plate as per QSI 004 & Dwg D3272

A/RAluminum Rod

3-Grind End Plate flush

Handwritten: 119785 120854

Handwritten: 10 12.05.17

Handwritten: Ae 12.05.23

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

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N9000040100

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Start Date: 25/04/2012 Start Qty: 10.00

10

Cust Item ID:

Required Date: 25/06/2012 Req'd Qty: 10.00

10

Customer:

Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

120

QC9- Inspect visual per QSI004- Fusion Welds

0.00

120

QC

Memo

0.00

Quality Control

10 0 2E 12/05/24

130

QC5- Inspect part completeness to step on W/O

0.00

130

QC

Memo

0.00

Quality Control

5/17/12/29

40
LH

140

Chemical Conversion Coat per QSI005 4.1

0.00

140

HandFinish

Memo

0.00

Hand Finishing

10 2AG 12-5-30

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

150

QC3- Inspect Part Finish

0.00

150

QC

Memo

0.00

Quality Control

10x

[Signature]
12/05/30

180

Large Fab

0.00

180

Large Fab

Memo

0.00

Large Fab

1-Assemble Leg Assembly as per Dwg D3272.

2-Leave one rivet out until welding is complete.

3-Bevel Aft end for welding

4-Inspect for foreign object as per QSI 024

5-Weld Aft End Plate as per QSI 004 & Dwg D3272
A/RAluminum Rod *M120854*

6-Grind End Plate flush

7-Install last rivet as per Dwg.

10 ϕ

Ae
12.05.30
12.05.30

Ae 12.06.04

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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Reference:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

190

QC10- Inspect visual per QSI004- ground welds

0.00

190

QC

Memo

0.00

Quality Control

200

QC5- Inspect part completeness to step on W/O

0.00

200

QC

Memo

0.00

Quality Control

210

Chemical Conversion Coat per QSI005 4.1

0.00

210

HandFinish

Memo

0.00

Hand Finishing

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Process Plan:

Date:

Tooling:

Date:

Run Start *NR1*

QC:

Date:

SPC (Y/N):

Date:

Stop *NR2*

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

220

White Gloss(Ref:4.3.5.1) per QSI005 4.3-Alum

0.00

220

Powdercoat

Powder Coating

Memo

START TIME:

OVEN TEMPERATURE:

FINISH TIME:

0.00

230

Wing Walk as per dwg QSI005 4.4 Batch 121613

0.00

230

HandFinish

Hand Finishing

Memo

0.00

240

QC3- Inspect Part Finish

0.00

240

QC

Quality Control

Memo

0.00

10X
LH
12/06/05
10
LH
12/06/05
(x10)
LH

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Process Plan:

Date:

Tooling:

Date:

Run Start ***NR1***

QC:

Date:

SPC (Y/N):

Date:

Stop ***NR2***

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Tool ID

Tool #

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

250

Pick Kit

0.00

250

Packaging

Memo

0.00

Packaging

10

12/06/06 JB

260

QC4- 100% Inspect kits for completeness

0.00

260

QC

Memo

0.00

Quality Control

8/7/06/07

40
64

270

Packaging

0.00

270

Packaging

Memo

0.00

Packaging

Identify and pack for shipping as per PPPD350-591-311

Location:

Rev D

10

80
12-6-7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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10

Customer:

Reference:

Approvals: Process Plan: Date:

Tooling: Date:

Run Start ***NR1***

QC: Date:

SPC (Y/N): Date:

Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

280

QC21- Final Inspection - Work Order Release

0.00

280

QC

Memo

0.00

Quality Control

12/6/18

MLJ 12/06/108

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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April-25-12 10:12:32 AM

Page 1

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D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 10.00

Required Qty: 10.00

Comments:

IPP Rev:A04.03.22New issue KJ/RF

IPP Rev:B 07-06-09 Added D3272-1 JLM

IPP C returned to CHG001 for Eurocopter, ref NCR08-082 LL verified

by:EC IPP Rev:D fixe route seq in bom DD 10.04.28 verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D3272-1		Manufactured	No			110	Each	20.0000	1	10			

D3272-1

Step

**

Ac 12.05.05

Location

Loc Qty

Loc Code

ST

-10

WA

B 83776

30

81312

10

81313

10

D3067-1

Manufactured

No

110

Each

187.0000

1

10

D3067-1

End Plate

**

12.05.16

Location

Loc Qty

Loc Code

WA

123

78608

4

80881

45

81969

74

WA016

64

67582

2

68214

1

79607

1

83053

60

10

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
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Work Order ID: 83772

Parent Item: D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

83772

D350-591-311

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 10.00

Required Qty: 10.00

D3219-1

Manufactured No

110

Each

323.0000

2

20

D3219-1

Plate

**

12.05.16

Location

Loc Qty

Loc Code

WA

84

82221

84

WA016

118

73410

12

77674

6

81292

80

82059

20

WA017

121

81971

121

20

D3066-1

Manufactured No

180

Each

101.0000

2

20

D3066-1

Spacer

**

B83854 (20) Ae 12.05.30

Location

Loc Qty

Loc Code

WA

101

81968

101

MS20600-AD4W4

Purchased No

180

Each

3,044.000

16

160

MS20600-AD4W4

Rivets

**

m118840 (160) Ae 12.05.30

Location

Loc Qty

Loc Code

ST321

3044

121011

9

121340

1035

121444

2000

April-25-12 10:12:32 AM

Shop Packet Print

Page 2

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

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Parent Item: D350-591-311

D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 10.00

Required Qty: 10.00

D3065-041

Manufactured No

180

Each

19.0000

1

10

D3065-041

Step Leg Assembly Hi

**

B80880 (10) Ae 12.05.30

Location

Loc Qty

Loc Code

WA

19

66149

0

78798

18

79336

1

D3067-1

Manufactured No

180

Each

187.0000

1

10

D3067-1

End Plate

**

12.05.30

Location

Loc Qty

Loc Code

WA

123

78608

4

80881

45

81969

74

WA016

64

67582

2

68214

1

79607

1

83053

60

AN3-35A

Purchased No

250

Each

127.0000

2

20

AN3-35A

Bolt

**

121652 JB 12/06/06

Location

Loc Qty

Loc Code

ST353

127

120644

50

120717

50

121068

27

April-25-12 10:12:33 AM

Shop Packet Print

Page 3

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Parent Item Name: Heli-Access-Step, Long LH

83772

D350-591-311

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 10.00

Required Qty: 10.00

D3235-1 Manufactured No

250 Each

39.0000

2

20

**

83311 JB

D3235-1

Mounting Lug

Location

Loc Qty

Loc Code

ST

39

78787

39

D3278-041 Manufactured No

250 Each

68.0000

0

10

**

83856 JB

D3278-041

Support Assembly

Location

Loc Qty

Loc Code

ST471

3

78795

3

ST481

65

82015

40

83361

25

AN960JD416 NAS1149D0463J Purchased No

250 Each

10.0000

16

160

**

121912 JB

AN960JD416

Washer

Location

Loc Qty

Loc Code

ST351

10

116289

10

AN960JD516 NAS1149D0563J Purchased No

250 Each

0.0000

4

40

**

119546 JB

12/06/06

AN960JD516

Washer

April-25-12 10:12:33 AM

Shop Packet Print

Page 4

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Parent Item Name: Heli-Access-Step, Long LH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 10.00

Required Qty: 10.00

AN5-36A

Purchased

No

250

Each

156.0000

20

AN5-36A

Bolt

** 6x121652 S

Location

Loc Qty

Loc Code

340

100

121181

100

14x121181 S

ST340

56

120187

6

120731

50

D2618

Manufactured

No

250

Each

190.0000

20

D2618

Bushing

** 83614 JB

Location

Loc Qty

Loc Code

ST012

190

76130

2

80474

188

D2230-3

Manufactured

No

250

Each

87.0000

40

D2230-3

Lug

** 83261 JB 12/06/06

Location

Loc Qty

Loc Code

ST480

87

53881

4

70973

1

81558

82

April-25-12 10:12:33 AM

Shop Packet Print

Page 5

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D350-591-311

Parent Item Name: Heli-Access-Step, Long LH

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 10.00

Required Qty: 10.00

D2856-400

Manufactured No

250 f

335.5345 1.2 12 ✓

D2856-400

Abrasion Strip

**

JB

Location

Loc Qty

Loc Code

ST403

216

81875

216

ST409

119.5345

63735

0.6696

68076

0.3149

71164

8.46

79551

110.09

~~81875~~ 5 ~

~~79551~~

*** cut (2) at 7.20" (D2856-400-720) ***

MS21042L3

Purchased No

250 Each

3,434.000

2 20 ✓

MS21042L3

Nut

**

JB

12/06/06

Location

Loc Qty

Loc Code

ST300

3434

117441

16

117885

32

118451

5

118927

3

119017

1340

119075

158

121349

880

121444

1000

121349 5 ~

W/O:		WORK ORDER CHANGES					
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Parent Item Name: Heli-Access-Step, Long LH

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D350-591-311

Start Date: 25/04/2012

Required Date: 25/06/2012

Start Qty: 10.00

Required Qty: 10.00

AN4-13A Purchased

No

250

Each

979.0000

80

**

AN4-13A

Bolt

Location

Loc Qty

Loc Code

ST357

979

119449

39

120187

19

120422

21

120770

400

121162

500

120770 S

MS21042L5

Purchased

No

250

Each

1,307.000

20

**

MS21042L5

Nut

Location

Loc Qty

Loc Code

ST300

1307

116105

5

116548

43

117611

30

119109

1229

119109 S

MS21042L4

Purchased

No

250

Each

5,814.000

80

**

MS21042L4

Nut

Location

Loc Qty

Loc Code

ST300

5814

116188

5

119017

4

119075

805

121011

2000

121444

3000

121011 S

AN960JD10

NAS1149D0363J

Purchased

No

250

Each

0.0000

40

**

AN960JD10

Washer

121524 JB

12/06/05

April-25-12 10:12:33 AM

Shop Packet Print

Page 7

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



DESIGN <i>qp</i>	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>LE</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D3272	REV. B SHEET 1 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE NTS
A	04.03.01	NEW ISSUE	
B	07.05.18	D3272-1 WAS D2622-120	

RELEASED

07.06.04 *[Signature]*

QTY -041	QTY -042	PART NUMBER	DESCRIPTION
X		D3272-041	STEP ASSEMBLY, HIGH LONG (LH)
	X	D3272-042	STEP ASSEMBLY, HIGH LONG (RH)
1	1	D3065-041	LEG ASSEMBLY
2	2	D3066-1	SPACER
2	2	D3067-1	END PLATE
2	2	D3219-1	SUPPORT
1	1	D3272-1	STEP
16	16	MS20600AD4W4	RIVET

GENERAL NOTES:

- 1) D3272-041 SHOWN. FOR D3272-042, INSTALL D3219-1 SUPPORT OPPOSITE SIDE
- 2) WELD PER DART QSI 004
- 3) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005.4.1
POWDER COAT ASSEMBLY WHITE (4.3.5.1) PER DART QSI 005 4.3
BLACK ANTI-SKID PAINT PER DART QSI 005 4.4
- 4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED.
- 5) ALL DIMENSIONS ARE IN INCHES UNLESS OTHERWISE NOTED.
- 6) BREAK ALL SHARP EDGES 0.005 TO 0.010 MAX.

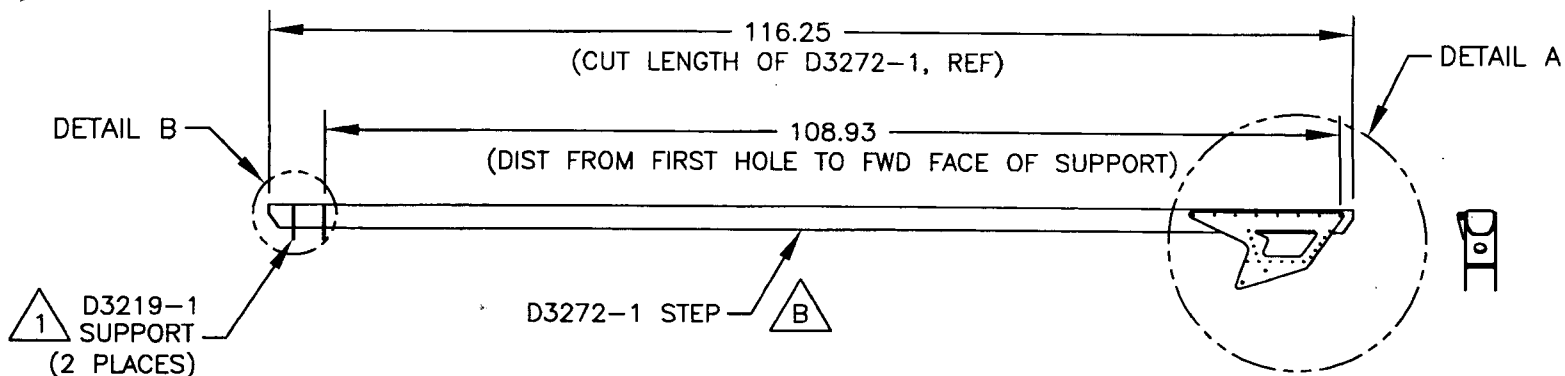
SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 83372 *MC*
12/04/20

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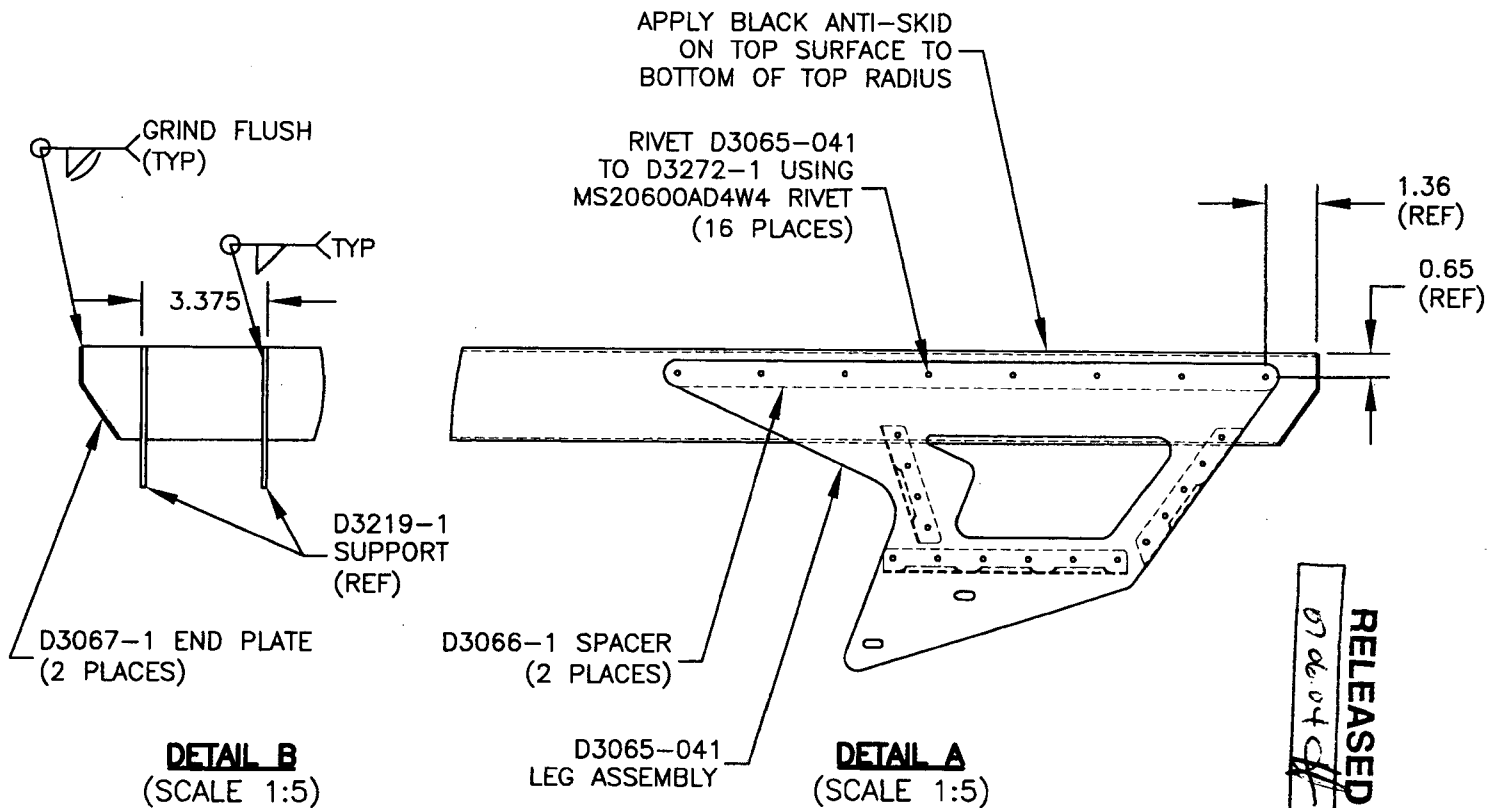
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83772

DART



D3272-041 STEP ASSEMBLY (LH. SHOWN)
D3272-042 STEP ASSEMBLY (RH, OPPOSITE)



RELEASED
07 de 04

DESIGN	90	DRAWN BY		DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
CHECKED	CE	APPROVED		REV. B
DATE	07.05.18	TITLE	D3272	SHEET 2 OF 3
			STEP ASSEMBLY, HI LONG	SCALE 1:20

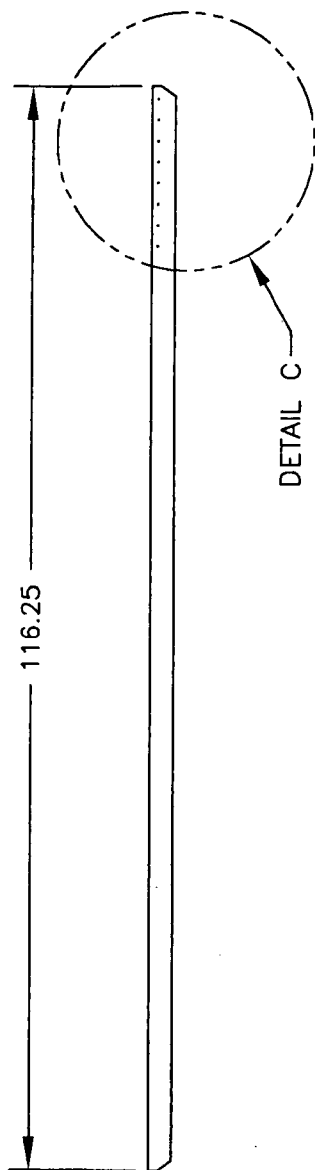
23 x 72



DESIGN 9P	DRAWN BY JS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED LE	APPROVED [Signature]	DRAWING NO. D3272	REV. B SHEET 3 OF 3
DATE 07.05.18		TITLE STEP ASSEMBLY, HI LONG	SCALE 1:20

RELEASED

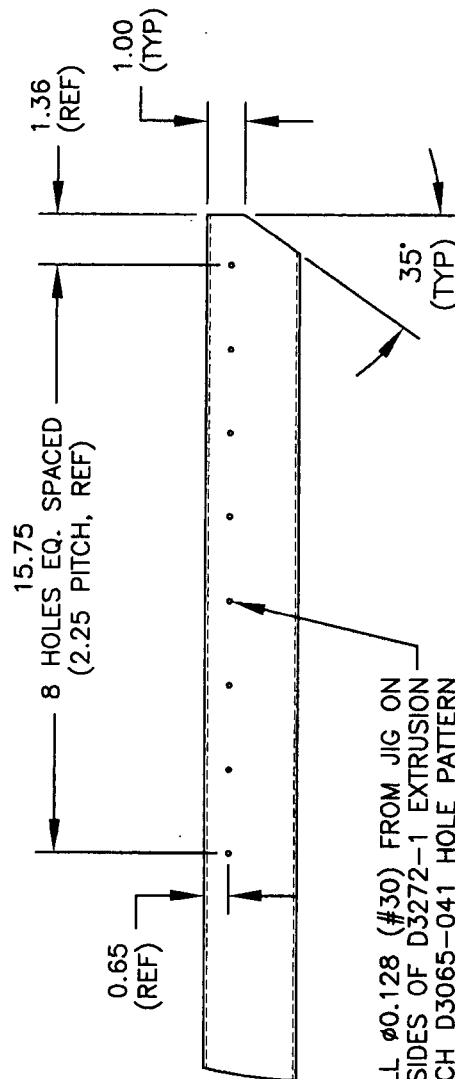
07.06.04 **[Signature]**



DETAIL C

B D3272-1 STEP

(MAKE FROM D2622-120 STEP EXTRUSION)



DRILL $\phi 0.128$ (#30) FROM JIG ON BOTH SIDES OF D3272-1 EXTRUSION TO MATCH D3065-041 HOLE PATTERN

DETAIL C
(SCALE 1:5)

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Qty -211	Qty -212	Qty -213	Qty -214	Qty -215	Qty -216	Qty -311	Qty -312	Part Number	Description
X								D350-591-211	Heli-Access-Step™, Long Step – High Skid, LH
	X							D350-591-212	Heli-Access-Step™, Long Step – High Skid, RH
		X						D350-591-213	Heli-Access-Step™, Short Step – High Skid, LH
			X					D350-591-214	Heli-Access-Step™, Short Step – High Skid, RH
				X				D350-591-215	Heli-Access-Step™, Short Step – Low Skid, LH
					X			D350-591-216	Heli-Access-Step™, Short Step – Low Skid, RH
						X		D350-591-311	Heli-Access-Step™, Long Step – High Skid, LH
							X	D350-591-312	Heli-Access-Step™, Long Step – High Skid, RH
1								D3070-041	STEP ASSEMBLY (HIGH-LONG, LH)
	1							D3070-042	STEP ASSEMBLY (HIGH-LONG, RH)
		1						D3078-041	STEP ASSEMBLY (HIGH-SHORT, LH)
			1					D3078-042	STEP ASSEMBLY (HIGH-SHORT, RH)
				1				D3168-041	STEP ASSEMBLY (LOW-SHORT, LH)
					1			D3168-042	STEP ASSEMBLY (LOW-SHORT, RH)
						1		D3272-041	STEP ASSEMBLY (HIGH-LONG, LH)
							1	D3272-042	STEP ASSEMBLY (HIGH-LONG, RH)
4	4							D2182B035	RUBBER CUSHION
		2	2	2	2			D2230-1	MOUNTING LUG
		2	2	2	2	4	4	D2230-3	MOUNTING LUG
8	8							D2274	RADIUS BLOCK
						2	2	D2618	BUSHING
4	4	4	4	4	4			D2732-030	CUSHION
2	2	1	1	1	1	2	2	D2856-400-720	ABRASION STRIP
2	2							D3064-1	CLAMP
1	1							D3079-041	SUPPORT ASSEMBLY
4	4							D3080-1	CLAMP
						2	2	D3235-1	MOUNTING LUG
						1	1	D3278-041	SUPPORT ASSEMBLY
2	2	2	2	2	2	2	2	AN3-35A	BOLT
10	10	2	2	2	2			AN4-11A	BOLT
		4	4	4	4	8	8	AN4-13A	BOLT
						2	2	AN5-36A	BOLT
4	4	4	4	4	4	4	4	AN960JD10	WASHER
20	20	12	12	12	12	16	16	AN960JD416	WASHER
						4	4	AN960JD516	WASHER
2	2	2	2	2	2	2	2	MS21042L3	NUT
10	10	6	6	6	6	8	8	MS21042L4	NUT
						2	2	MS21042L5	NUT
						1	1	DSI 9410-011	STEP MODIFICATION KIT

*DSI 9410-011 Step Modification Kits are provided with all D350-591-311 and D350-591-312 Steps. This kit is provided as an option for the installer and is therefore **NOT REQUIRED** to complete the installation of the D350-591-311 or D350-591-312 Steps. Refer to Figure 21 for installation of the DSI 9410-011 Kit.